

79878

Page 1

N900040100

Setup Start ***NS1***

Stop ***NS2***

7

7

Run Start *NR1*

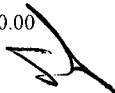
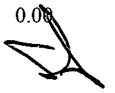
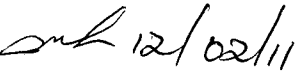
Date: 12/02/07

Date:

Stop *NR2*

Date:

Date:

100	MORI SEIKI CNC LATHE LARGE	0.00	7 0
100		0.00	
Doosan	Memo	 12/2/9	
Doosan Lathe	Turn blank as per Folio FA082 check bore with DT8495		
110	QC2- Inspect parts off machine FAI/FAIB	0.00	7 0
110		0.00	
QC	Memo	 12/2/9	
Quality Control			
120	QC8- Inspect parts - second check	0.00	7 0
120		0.00	
QC	Memo	 12/02/11	
Quality Control			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79878

79878

Page 2

February-07-12 8:31:57 AM

Item ID: DSK077 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2892-1 TURNING DETAIL
 Start Date: 06/02/2012 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 21/02/2012 Req'd Qty: 7.00 ***7*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>MAT60</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

am R 12/02/11

7

12/2/13

R 12-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-07-12 8:32:01 AM

Page 1

Work Order ID: 79878

79878

Parent Item: DSK077

DSK077

Parent Item Name: D2892-1 TURNING DETAIL

Start Date: 06/02/2012

Required Date: 21/02/2012

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-003		Manufactured	No				Each	25.0000					
-----------	--	--------------	----	--	--	--	------	---------	--	--	--	--	--

D6104-003

Round Billet, 17-4

**

SA 12/2/9

Location	Loc Qty	Loc Code
MAT043	9	
60943	3	
66960	1	
72807	5	
MAT047	16	
77628	16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

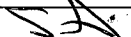
NOTE: Date & initial all entries

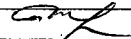
DART AEROSPACE LTD		Work Order:	79878
Description: Turning Detail for D2892-1		Part Number:	DSK077
Inspection Dwg: DSK077		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET


☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.529	2.529	2.529	2.529	2.529
B	3.702	3.722		3.714	3.714	3.712	3.712	3.712
C	2.814	2.834		2.823	2.823	2.823	2.823	2.823
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.714	2.734		2.723	2.723	2.723	2.723	2.723
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	3.214	3.234		3.224	3.224	3.223	3.224	3.223
I	0.913	0.933		.926	.926	.926	.926	.926
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.098	.098	.097	.098	.098
L								
M								
N								
O								
P								

Measured by:  **Date:** 12/2/19

Audited by:  **Date:** 12/02/11

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79878
Description: Turning Detail for D2892-1		Part Number:	DSK077
Inspection Dwg: DSK077		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	14	3	4	5
Lathe Section								
A	2.524	2.529		2.529	2.529			
B	3.702	3.722		3.711	3.712			
C	2.814	2.834		2.823	2.823			
D	0.718	0.738		.726	.726			
E	0.090	0.110		.101	.101			
F	2.714	2.734		2.725	2.723			
G	2.029	2.049		2.040	2.040			
H	3.214	3.234		3.225	3.222			
I	0.913	0.933		.926	.926			
J	0.022	0.042		.031	.031			
K	0.090	0.110		.098	.098			
L								
M								
N								
O								
P								

Measured by:	SA	Date:	12/2/9
Audited by:	amx	Date:	12/02/11
Prototype Approval:		Date:	

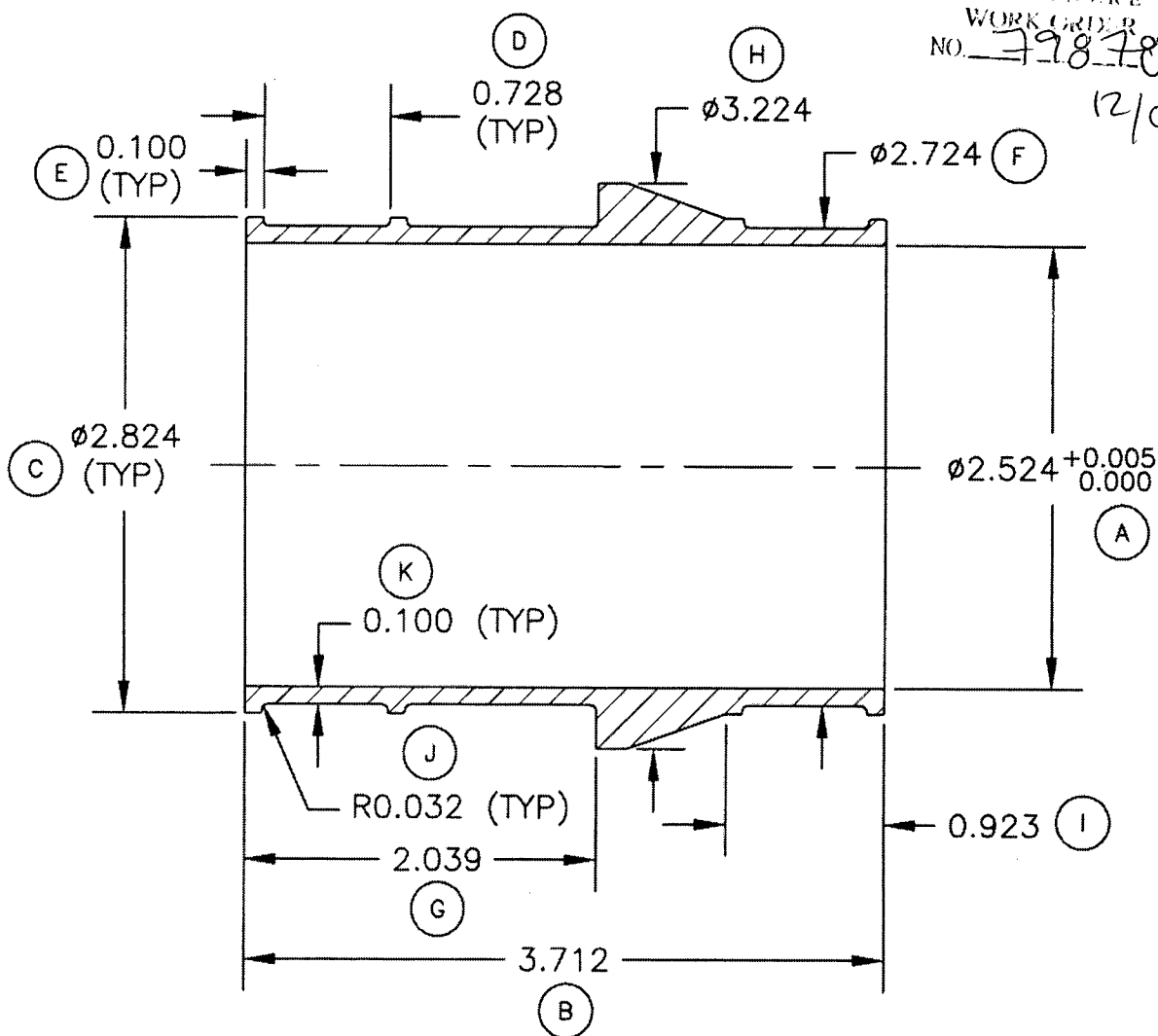
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA



DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 077	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2892-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

ISSUED BY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 79878 H.L.S
12/02/07



D2892-1 TURNING DETAIL

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NOTE: Date & initial all entries